

# Work Order ID 64110

Wednesday, November 24, 2010 1:14:17 PM

Page 1

Item ID: D3929-041

Accept

Revision ID:

Item Name: Gusset Assembly

Start Date: 11/24/2010 Start Qty: 6.00

Required Date: 11/30/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date: 10-11-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	Rev A								
100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet	Memo 1-Cut as per Dwg D3929 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

10-11-25

7

10-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Required Date: 11/30/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: M114649

150

0.00



QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



Siolub6

77

10/12/01 7x

10.12.02

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 64110**

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Wednesday, November 24, 2010 1:14:17 PM

Item ID: D3929-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 11/24/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



0.00 8/12/07

QC

Memo

Quality Control



170

Identify as per dwg &amp; Stock Location:

0.00



Basket cell

0.00

Packaging

Memo

Packaging

10/12/01 (7X)

180

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

10/12/03  
MF  
10-12-02

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, November 24, 2010 1:14:21 PM

Page 1  
T

Work Order ID: 64110

Parent Item: D3929-041

Parent Item Name: Gusset Assembly



Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 6.00

Required Qty: 6.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

34.7523

0.45

2.842105



304/316 0.125 Sheet



1810-11-25

### Location

### Loc Qty

### Loc Code

MAT

34.7523

114799

34.7523

D3907-1

Manufactured

No

130

Each

49.0000

2

12



114799

(7)

10/12/01

Bushing

### Location

### Loc Qty

### Loc Code

WA

49

60720

5

62149

4

63561

40

14x

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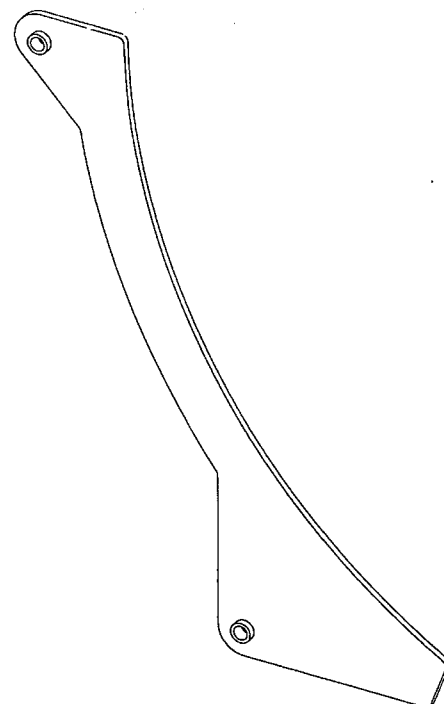
**NOTE:** Date & initial all entries



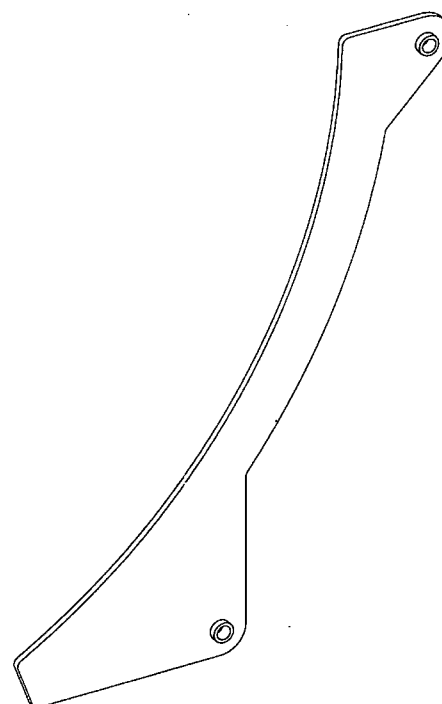


8 7 6 5 4 3 2 1

ITEM	QTY .041	QTY .042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44110

PS 10-11-24

RELEASED  
3/6/12

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.73 lbs EACH
  - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03	
REV.		DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. /
MFG. APPR.			D3929	SHEET 1 OF
APPROVED			TITLE	SCALE
DE APPR.			<b>GUSSET ASSEMBLY</b>	NTS
DATE	09.04.03			
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8 7 6 5 4 3 2 1

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D3929-1  
SUPPORT GUSSET  
2 PL

0.25  
2 PL, REF

D3907-1  
BUSHING  
2 PL

2 PL

D3929-1  
SUPPORT GUSSET  
REF

**D3929-041 GUSSET ASSEMBLY**

D3929-1  
SUPPORT GUSSET  
2 PL

*WLOG4110*

2 PL

D3907-1  
BUSHING  
2 PL

0.25  
2 PL, REF

D3929-1  
SUPPORT GUSSET  
REF

**D3929-042 GUSSET ASSEMBLY**

**RELEASED**  
*09/04/22*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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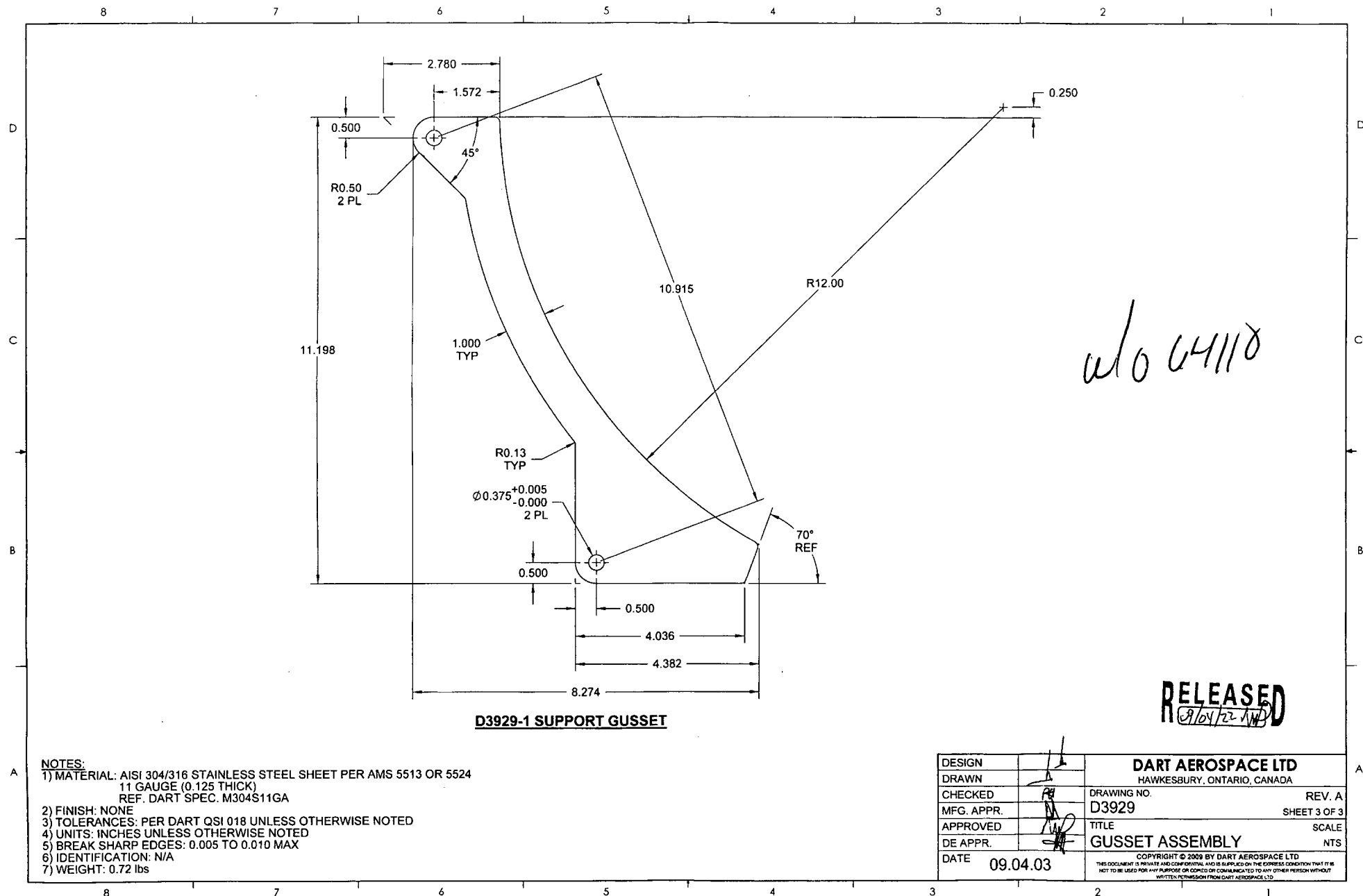
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